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SPUT

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23769
<b>Description:</b> Handle Assembly	<b>Part Number:</b>	D3331-041
<b>Dwg:</b> D3331 Rev. B C	<b>Qty:</b>	20 15
05.07.06		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.07.06	20
2	MFA	Cut handle to finish length as per Dwg D3331 Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall (M1025TR0.875W.125) <b>Identify for D3331-1</b>	M18027 CPL	05.07.11	15
		Batch: M17014	<del>CPL 05.07.08</del>	<del>5</del>	
3	MFA	Form as per Dwg D3331 using DT8760 crimping Jig	CPL	05.07.11	15
4	CL	Turn as per Dwg D3331	<del>CPL 05.07.08</del>	<del>5</del>	
5	QC2	Inspect parts as they come off the machine <b>Identify as D3331-1</b>	CPL	05.07.11	15
6	QC8	Second check	<del>CPL 05.07.08</del>	<del>5</del>	
7	MC	Deburr	CPL	05.07.11	15
8	MFA	Drill dowel hole as per Dwg D3331	<del>CPL 05.07.08</del>	<del>5</del>	
9	MFA	Insert and Weld dowel as per Dwg D3331 <b>Pick:</b> Qty Part Number Description Batch 1 1 A/R N/A 3/16"-1" long Dowel M16922 Steel Rod M19326	CPL	05.07.11	15
10	QC5	Inspect work to Step 9	<del>CPL 05.07.08</del>	<del>5</del>	
11	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	ML	05.08.11	15
12	QC3	Inspect Powder Coat	CL	05.08.16	15
14	MFA	Assemble as per Dwg D3331 <b>Pick:</b> Qty Part Number Description Batch 1 GP-78R Black Vinyl Grid M16372 1 D3158-050 Heat Shrink 322097	CPL	05.08.16	15
15	QC5	Inspect work to Step 14	<del>CPL 05.08.16</del>	<del>15</del>	
16	ST	Identify and Stock	CL	05.08.122	15
17	AC	Cost / part: 19.75			
18	DC	Close W/O 20.46 Inspect Level 21	CL	05.08.23	15

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	
B	05.03.03	Revised Step 4 & 5	KJ/JLM	
C	05.05.26	Added D3158-050	KJ/JLM	

RELEASED  
05.05.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

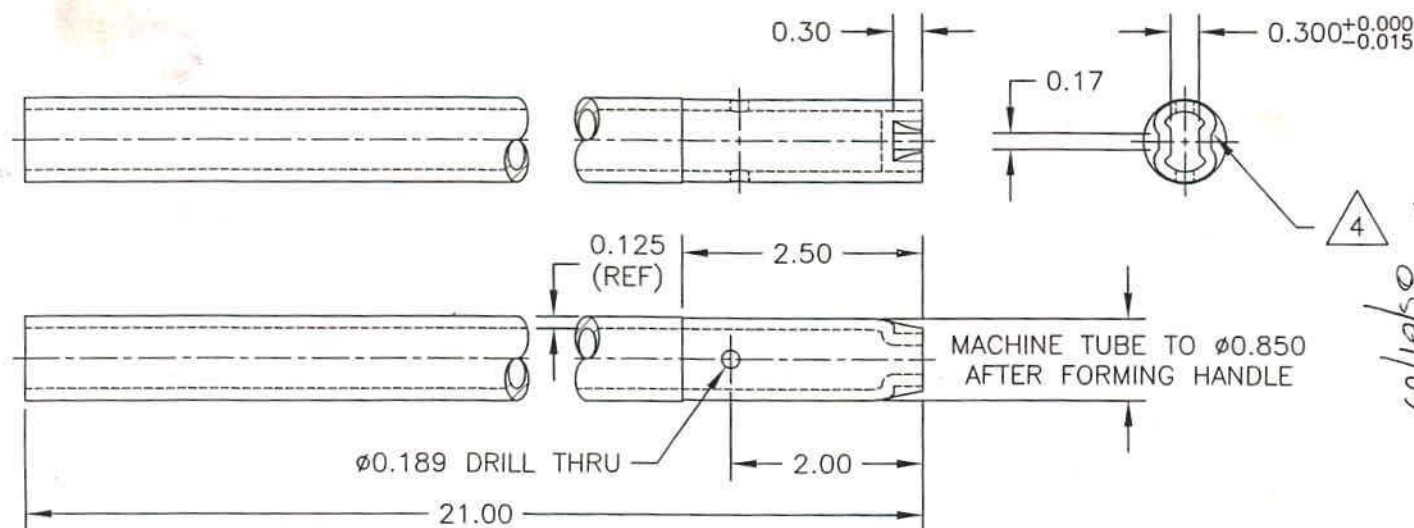
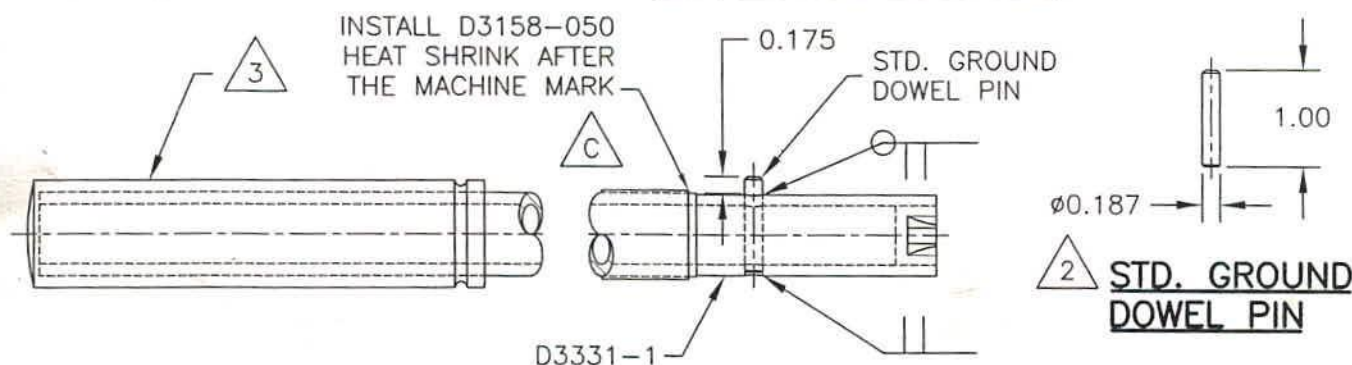
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/08/23

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





**DART****RELEASED**  
05/07/05**1 D3331-1 HANDLE****D3331-041 HANDLE ASS'Y****2 STD. GROUND DOWEL PIN****NOTES:**

- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR0.875W.125)
- 2) STD. GROUND DOWEL PIN,  $\phi 3/16"$  x 1.00" LONG  
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
- 3) STD. BLACK VINYL GRIP, 7/8" I.D. x 4 3/4" LONG  
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
- 4) FORM USING TOOLING DT8760
- 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	DRAWING NO. D3331	SHEET 1 OF 1
DATE		TITLE	SCALE
05.05.20		HANDLE WELDMNT	1:2
A	04.11.29	NEW ISSUE	
B	05.02.18	LENGHT 21.00 WAS 18.00	
C	05.05.20	ADD D3158-050	

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 23769



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 06, 2005  
11:42 am

Work Order No : 0023769  
Project Name : D3331-041  
Project For : WK530  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3331-041  
Description : Handle Assembly  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 07-06-05  
Est Finish Date : 07-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00